110

Quality Control

QC

Memo

April-18-13 1:23:19 PM Item ID: D3913-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Long Basket Base Assemby. 350 Start Date: 4/18/13 Start Qty: 1.00 Cust Item ID: Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Approvals: Process Plan: MLJ Date: 13-04-18 Tooling: Stop _____ Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Reject Work Center ID Description Run Hours Code Qty Qty Number Stamp Draw Nbr Revision Nbr D3913 В D4020 Α Weld per dwg A/R S.S. rod Batch: B 124816 100 Large Fab *100* BCC 13-5-6 Large Fab 0.00 Memo Large Fab 1- assemble ribs, weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

0.00

NCR: Y	es / No				WOF	RK ORDER NON-C	ONFO	ORN	AANCE / UP	DATE	QA Closed:	Date	:
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Root				Descri	ption of	work order update	Initi	al	Ac	tion	Sign &		
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	Crushed/	Crimped			Burrs		Ins	truct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cúffs				Contam	ination	Ма	ainte	nance		Part Moved		
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	Wave/Tv				Folio		——		Dimensions		*		

Date:

DQA:

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Work Order ID 100167 · 4 (2019 1)

Memo

April-18-13 1:23:19 PM

HandFinish

Hand Finishing

100167

Item ID: D3913-041 Accept *N900040100* Setup Start **Revision ID:** Long Basket Base Assemby. 350 Item Name: *1* **Start Date:** 4/18/13 Start Qty: 1.00 Cust Item ID: Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: ____ Date: ____ **Approvals:** Tooling: Date: _____ Stop QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Qty Qty Code Number Stamp 120 QC5- Inspect part completeness to step on W/O 0.00 *120* QC 0.00 Memo Quality Control 125 Pressure Wash per QSI005 4.3 0.00 1 6 18-5-7. BK *125*

0.00

NCR: Y	es /	No				W	ORK ORDER NON-C	CON	NFORM	/IANCE / UP	DATE	QA Closed:	Date:	
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Work Orde	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	<u> </u>
							Rework			Skid-tube	Crosstube]	Water Jet	Engineering
Part N	۱o						Scrap]	ſ	Machining	Small Fab	4	d. Eng. Coor.	Quality
						4	Use-as-is]		noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	No						Work Order Update	<u> </u>		Large Fab	Composite	j	Supplier	
Root					Descri	ption	of work order update		nitial	Ac	ction	Sign &		
Cause	1	Date	Step	Qty	(or Nor	-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
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DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Insp.

100167 April-18-13 1:23:19 PM Item ID: D3913-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Long Basket Base Assemby. 350 **Start Date:** 4/18/13 Start Qty: 1.00 Cust Item ID: Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Tooling: **Approvals:** Date:____ Stop Date: _____ SPC (Y/N): Date:____ Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID **Description Run Hours** Code Qty Qty Number Stamp 130 White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel 0.00 *130* Powdercoat 0.00 Memo Powder Coating 1- Plug holes and mask only interior of hinge (3) prior to powder m125069

2ND COAT: ام درا START TIME: **OVEN TEMPERATURE:** FINISH TIME:

140

QC3- Inspect Part Finish

0.00

140

Memo

Quality Control

0.00

1 8 5-7.

NCR:	Yes	/ No		•		WC	ORK ORDER NON-	COI	VFORI	MANCE / UP	DATE			
												QA Closed:	Date:	The second secon
Work Orde	er:						DISPOSITION	7			AGAINST DE	PARTMENT		
Part I							Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root			T .		Descri	ption (of work order update	П	nitial	Ac.	tion	Sign &	*	
Cause		Date	Step	Qty			-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
опарриотов	<u> </u>	L	1	J			F	AUL	T CATE	GORY				,
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		Bending Centre No Cracks Crushed/ Cuffs Heat Treat Inspection	'Crimped at in Strip in	-	o/s	Brok Burrs Conta Cour	I/Route en/Damaged		4	ion Incomplete tions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque V	Vaves in E	Extrusio	n 「	Draw	ving		Out of	Calibration				

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:23:19 PM

Item ID:

D3913-041

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Long Basket Base Assemby. 350

Cust Item ID:

Tool # Plan

Code

4/18/13 Required Date: 5/02/13 Start Oty: 1.00 Req'd Qty: 1.00

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling:

Date:

Date:

Run

Reject

Stop

Reject

Qty

Number Stamp

Insp.

Sequence ID/ Work Center ID

150

150

HandFinish Hand Finishing Operation Description

Assemble as per dwg

Memo

Pick Kit

Memo

QC: ____ Date: ___

Set Up/ **Run Hours**

0.00

SPC (Y/N):

0.00

160

160

Quality Control

QC5- Inspect part completeness to step on W/O



Accept

Qty

170

Identify as per dwg & Stock Location: 14030- 04600

100154

170

Packaging Packaging

0.00

1 \$ Bl 13-5-7.

Memo

NCR: Y	es / No				WC	ORK ORDER NON-C	CONF	ORN	MANCE / UP	DATE	QA Closed:	Date:	
Mark Orda						DISPOSITION			AWA	AGAINST DE	PARTMENT	PROCESS	
Work Orde	r:					Rework]		Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	0				İ	Scrap	↓		Machining	Small Fab	i	d. Eng. Coor.	Quality
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Cause	Date	Step	Qty	1	or Non	-conformance	Chie	f Eng	Desc	cription	Date	Verification	QC Inspector
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	Cracks			<u></u>	⊣ /	en/Damaged	-	-	ion Incomplete	_	Part Incorre	—	Weld
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	Heat Trea	at		_	⊣ 1	tersink	\vdash	1islabe			Positioned V		٦
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Ĺ	Turning S	Sequence			Finish		\vdash		Sequence				
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DQA: _____Date: ____

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April-18-13 1:23:19 PM

Required Date: 5/02/13

Item ID:

D3913-041

Accept

N900040100

Setup Start

NC1

NC2

Item Name:
Start Date:

Revision ID:

4/18/13

QC:

Start Qty: 1.00 Req'd Qty: 1.00

Long Basket Base Assemby. 350

1

Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date:_

Date: _____ Tooling:

Date:

Run Start

art *NP1

Stop

NR2

Sequence ID/ Work Center ID Operation Description

Set Up/ Run Hours

SPC (Y/N):

Tool ID Tool # Plan

Date:

Plan Accept Code Qty

Reject Qty Reject Insp. Number Stamp

180

*1**8**0*

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

MUS 13-05-08

Quality Control

Q(3-05-8

											DQA:	Date:	
NCR: Y	es / No				WC	RK ORDER NON-C	CON	IFORN	AANCE / UPD		OA Clasad:	 Date:	
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Mark Ord-	r·					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Work Orde	r:					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	0					Scrap	1 1		Machining	Small Fab	Prod	l. Eng. Coor.	Quality
raitiv	·					Use-as-is	1 1		noforming	Finishing	<u> </u>	e/Packaging	Other
NCR N	0.				,	Work Order Update	1		Large Fab	Composite	·	Supplier	· 🔲
Root				Descr	•	f work order update	1	nitial	Acti		Sign &		·
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Ī	Crushed/	Crimped		Γ	Burrs			Instruct	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
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	Inspectio	n Strip in	Tube		Cut T	oo Short		Misread	t		Power Loss/	Surge	Other
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[Turning S	equence			Finish			ł	Sequence				
	Wave/Tw	ist in Tul	эe	i	Folio			Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100167

D3913-041

100167

Parent Item Name: Long Basket Base Assemby. 350

D3913-041

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

CC 13-5-1

Comments:

Parent Item:

IPP Rev:A new issue DD 10.03.19 verified by:EC

Manufactured

chg qty's DD 10.04.12 verified by:EC

IPP REV:C 12.07.24

AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	72.0000	2	2			+
D2581									**		PP	12.5	- 1

IPP Rev:B

Mounting Bracket

Location	<u>Lo</u>	c Oty	Loc Code			91
WA		44 R 9	8503	<u></u> >	_ (Zx	_
98503		44				
WA004		28				
70766		2				
81253		1				
82506		2				
83230		3				
85452		2				
87706		2				
98108		16				
	100	Each	4.0000	1	1	

Rib

D3913-1

Location WA005 87543 94826

NCR: Ye	s / No				WO	RK ORDER NON-C	CON	FORN	MANCE / UPD	DATE	QA Closed:	Date	-
Work Order						DISPOSITION				AGAINST DE	PARTMENT,	_	
Part No					,	Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
		1	1	D		£	100	itial	Acti	ion	Sign &		
Root	D.4.	Chara	04		•	f work order update -conformance	1	ef Eng	Descri		Date	Verification	QC Inspector
Cause	Date	Step	Qty		or won	-conformance	Crite	er Eng	Descri	iption	Date	verification	QC III3pector
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Operator	\dashv												
Material			*										
Setup	\dashv		'		ĺ								
Other Process	-						ĺ						
Supplier					ļ		İ						
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Stiapproved 1	<u> </u>	l	1			F	AULT	CATE	GORY			<u> </u>	
Landing	Gear					General							
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-	Centre No	ot Conce	ntric to			/Route	\vdash	Hardwa	re		Over/Under	tolerance	Temperature/Cure
-	Cracks			-,-	⊣ '	n/Damaged			on Incomplete	 	Part Incorre	- -	Weld
-	Crushed/	Crimped			Burrs	,8		•	ions Incomplete/U	Jnclear	Part Lost/M	ssing	Wrong Stock Pulled
-	Cuffs	орса.		<u> </u>		mination *	\vdash		nance		Part Moved		
<u> </u>	Heat Trea	ıt	•	-	1	tersink		Mislabe			Positioned V	Vrong	
-	Inspection		Tube	 	-	oo Short	\vdash	Misreac		ļ —	Power Loss/	, L	Other
<u> </u>	Ripples in			-	Drill		\vdash	Offset		L	- .	- L	
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<u> </u>	Turning S				Finish	-	\vdash		Sequence			·	
<u> </u>	Wave/Tw	•			Folio		-		Dimensions				

DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:23:22 PM

Work Order ID: 100167

100167

Parent Item:

D3913-041

D3913-041

Location

Location

WA004

WA005

Parent Item Name: Long Basket Base Assemby. 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D3913-15

D3913-3

D3913-7

Manufactured

Each

13.0000

Loc Code

**

13-5-1

D3913-15

Wide Handle Plate

No

Manufactured No WA004 90084

94825

69160 84651 94165

13 100 Each

Loc Qty

100

7.0000

Loc Code

**

CC 13-5-1

D3913-3 Rib

> Manufactured No

Loc Qty 2 100

Each 7.0000 **

2

CC 13-5-1

D3913-7 Rib

> Location WA005

88492

NCR: Ye	es / No				W	ORK ORDER NON-C	ON	NFORM	MANCE / UP	DATE	0	- A Closed:	Date	۵۰
	3.49		ţx .		ľ	DISPOSITION			A CAMPAGE CONTRACTOR	AGAINST I		78. n <u>e</u>	"	С.
Work Order	:						,					•	_	
						Rework			Skid-tube	Crosstube	_	_	Water Jet	Engineering
Part No	D					Scrap			Machining	Small Fab			d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing		Rec/Stor	e/Packaging	Other
NCR No	D					Work Order Update	<u> </u>		Large Fab	Composite			Supplier	
Root				Descri	iption	of work order update	ı	nitial	. Ac	tion		Sign &		
Cause	Date	Step	Qty	1	or Nor	conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector
Doc/Data					-									
Equip/Tooling														
Operator							1							
Material														
Setup		·												
Other														
Process											-			
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Landing	g Gear				_	General		•		,			-	· •
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	Centre No	ot Concer	ntric to (o/s	JBO№	/Route		Hardwa	ire	ļ	\Box \circ	ver/Under	tolerance	Temperature/Cure
	Cracks				Brok	en/Damaged		Inspecti	ion Incomplete		P.	art Incorred	ct _	Weld
	Crushed/0	Crimped.			Burrs	-		Instruct	ions Incomplete/	/Unclear	P	art Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs		, .	:	Cont	amination .		Mainte	enance		P:	art Moved		
	Heat Treat					ntersink		Mislabe	eled		P	ositioned V	Vrong	
	Inspection	n Strip in	Tube		Cut	oo Short		Misread	d		P	ower Loss/	Surge	Other
	Ripples in	Bend			Drill	Holes		Offset						
	Torque W	aves in E	xtrusio	n	Drav	ving		Out of (Calibration					
	Turning S	equence			Finis	า		Out of 9	Sequence					
	Wave/Tw	ist in Tub	oe .		Folio)		Outside	Dimensions					

DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-18-13 1:23:22 PM

Work Order ID: 100167

Parent Item:

D3913-041

100167

D3913-041

Parent Item Name: Long Basket Base Assemby. 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

13-5-1

D3913-9

Manufactured

No

100 Each

Loc Qty

12.0000

Loc Code

**

CC 13-5-1

D3913-9

Hinge Rib

Location WA 94814 WA005 70138

100

11 Each 8.0000

D3916-041

Manufactured

Rib Assembly

Location WA004

94818

WA005

81444

Loc Qty 2

Each

D3916-5

Manufactured

No

100

14.0000

**

CC 13-5-1

D3916-5 Light Rib

> Location WA004 94163

94698 WA005 77142 82933

Loc Qty

NCR:	Yes / No				WO	RK ORDER NON-	CONF	ORN	MANCE / UP	PDATE					
					g-r						(QA Closed:	Da	ete:	No. of the second secon
Work Orde	or:					DISPOSITION				AGAINST	T DEP	PARTMENT	PROCESS		
WOIR Olde	cı					Rework	1 I		Skid-tube	Crosstube	еП		Water Jet		Engineering
Part N	No.				İ	Scrap	1		Machining	Small Fak		Pro	d. Eng. Coor	.H	Quality
	-			-		Use-as-is	1 ⊤		noforming	Finishing	g		e/Packaging		Other
NCR 1	No	···			V	Work Order Update]		Large Fab	Composite	e		Supplier		
Root		T		Descri	ption o	f work order update	Init	ial	Ac	ction		Sign &	· · · · · · · · · · · · · · · · · · ·		
Cause	Date	Step	Qty	(or Non	-conformance	Chief	Eng	Desc	cription		Date	Verification	on	QC Inspector
Doc/Data		}									l				
Equip/Tooling															
Operator											İ				
Material		1												Ì	
Setup		1									l				
Other											İ			İ	
Process															
Supplier															
Training															
Unapproved			<u> </u>				<u> </u>								
							AULT (CATE	GORY						
Landi	ng Gear			_	,	General									l- <i>(</i> -)
	Bending			<u>_</u>	Bend			rain				Ovalized		\vdash	Pressure/Forced
		ot Conce	ntric to	o/s	⊣ ∣`	Route (\vdash	ardwa				Over/Under			Temperature/Cure
	Cracks				- 1	n/Damaged	\vdash	•	ion Incomplete		\vdash	Part Incorre		\vdash	Weld
		/Crimped	٠.		Burrs				ions Incomplete	/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
	Cuffs				-;	mination	-		enance		\vdash	Part Moved			
	Heat Tre	at			-1	tersink	Шм	islabe	eled			Positioned V	_		1
	—	on Strip in	Tube	_	-	o Short	 	isread	t			Power Loss/	Surge		Other
	Ripples i			· .	Drill H		\vdash	fset			,				
	Torque V	Waves in I	Extrusio	n L	Drawi	ing			Calibration						
	Turning !	Sequence			Finish			ut of 9	Sequence						
	Wave/Tu	wist in Tul	be ·	1	Folio		1 0	utside	Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print April-18-13 1:23:22 PM Work Order ID: 100167 *100167* Parent Item: D3913-041 *D3913-041* Parent Item Name: Long Basket Base Assemby. 350 **Start Date: 4/18/13** Required Date: 5/02/13 Start Qty: 1.00 Required Qty: 1.00 D4016-1 Manufactured No 100 Each 52.0000 Hinge Half, Base Location Loc Qty Loc Code ST044 17 99098 17 WA 24 24 WA005 11 94481 11 D4017-7 Manufactured No 100 Each 6.0000 *D4017-7* ** CC 13-5-1 Location WA004 95102 WA005 69730 82969 85435 88392 D4017-9 Manufactured No 100 Each 9.0000 CC 13-5-1 ** Rib

D4017-9

Location Loc Qty Loc Code WA004 95203 WA005 70341 81445

NCR: Ye	es / No				WO	RK ORDER NON-C	CON	FORN	MANCE / UPD	DATE	QA Closed:	 Date	:
Work Order	•					DISPOSITION				AGAINST DE	PARTMENT		
Part No	o	•			,	Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	→	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption c	f work order update	ln	itial	Acti	ion	Sign &		
Cause	Date	Step	Qty		•	conformance	Chie	ef Eng	Descr	iption	Date	Verification	QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training	oling								. •				
Unapproved	<u> </u>	l	<u> </u>				A	CATE	CORV		1		<u> </u>
							AULI	CATE	GURY				
Landin	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence					General /Route en/Damaged mination tersink so Short Holes ing		nstruct Mainte Mislabe Misread Offset Out of (on Incomplete ions Incomplete/U enance eled d	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turning S Wave/Tw			-	Finish Folio		\vdash		Sequence Dimensions		<u></u>		

DQA:

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Page 5

Picklist Print

April-18-13 1:23:22 PM

Work Order ID: 100167

100167

Parent Item:

D3913-041

D3913-041

Parent Item Name: Long Basket Base Assemby. 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

**

Required Qty: 1.00

D4020-11

Manufactured

Manufactured

Manufactured

No

No

No

100

Each

11.0000

CC 13-5-1

End Mesh, Basket

Location WA007 81442 84972 94553

97684

100 Each

Loc Qty

29.0000

**

Handle Plate

D4034-041

D4021-1

Location WA004

98356

Loc Qty 3 14

2 Each 4.0000

**

13-5-1

Aft Upper Rib Assembly

Location WA005

84048 93187

Loc Qty

3

100

Loc Code

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	CONF	ORM	IANCE / UPDATE	•		+
					·				QA Closed:	Date:	
Marali Ondo		.	••		DISPOSITION			AGAINST D	EPARTMENT	/PROCESS	
Work Orde	r:				Rework	7		Skid-tube Crosstube		Water Jet	Engineering
Part N	o				Scrap Use-as-is	 .	٨	Machining Small Fab oforming Finishing		d. Eng. Coor.	Quality Other
NCR N	0				Work Order Update		1	Large Fab Composite		Supplier	
Root				Descrip	otion of work order update	Ini	tial	Action	Sign &		
Cause	Date	Step	Qty	0	r Non-conformance	Chie	f Eng	Description	Date	Verification	QC Inspector
Doc/Data	_										
quip/Tooling											
Operator	_								İ		
Material	_										
Setup						İ					
Other											
Process	_						l				1
Supplier		i									
Training	_	i.									
Unapproved		<u> </u>	<u> </u>	<u> </u>		AULT	CATE	GORY			
Landin	g Gear				General						
[Bending				Bend	ПG	irain		Ovalized	Γ	Pressure/Forced
ļ	Centre No	ot Conce	ntric to	o/s	BOM/Route	Пн	ardwa	re	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ir	nspectio	on Incomplete	Part Incorre	ct _	Weld
	Crushed/	Crimped			Burrs	Ir	istructi	ions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
Ī	Cuffs		:		Contamination	□ ^	/lainte	nance	Part Moved		
ļ	Heat Trea	at			Countersink	\square	/lislabel	led	Positioned \	Wrong	
Ī	Inspectio	n Strip in	Tube		Cut Too Short	\square	∕lisread		Power Loss,	/Surge	Other
ſ	Ripples in	Bend			Drill Holes		ffset				
	Torque W	Vaves in I	Extrusio	n [Drawing		ut of C	Calibration			
	Turning S	equence	ı		Finish		ot of S	equence		· · · · · · · · · · · · · · · · · · ·	
ſ	Wave/Tw	ist in Tul	be		Folio	c	utside	Dimensions			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-18-13 1:23:22 PM

Work Order ID: 100167

100167

Parent Item:

D3913-041

D3913-041

Parent Item Name: Long Basket Base Assemby. 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D4034-043

Manufactured No 100

Each 5.0000

13-5-1

CC 13-5-2

Fwd Upper Rib Assembly

Location Loc Qty WA005 82980 94490 3

D4672-1

Manufactured No 100

100

16.0000

Loc Code

Blanking Plate

Loc Qty

Loc Code

**

**

88253 94551

Location

WA005

Location

MAT

10 sf

596.0191

33 33

M304EX0.75-16F

Purchased

No

M304FX0 75-16F

Expanded Metal Flat SS

Loc Qty

516.0591180 K

Each

Loc Code

516.059118 64

WA 124466 64 WA007

123448

125113

15.96 15.96

April-18-13 1:23:23 PM

NCR: Y	es / No				WC	RK ORDER NON-C	ON	IFORN	MANCE / UP		QA Closed:	Date	
	······································	. ········											
Work Orde	r:					DISPOSITION	1			AGAINST DE	PARTMENT/	PROCESS	
		31.75m/1			1	Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.					Scrap]		Machining	Small Fab	l .	d. Eng. Coor.	Quality
					1	Use-as-is			noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo					Work Order Update	J		Large Fab	Composite		Supplier	
Root				Descri	ption (of work order update	1	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non	-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data							ļ						
Equip/Tooling		-											
Operator		ŀ											
Material		ļ											
Setup													
Other						,			1				
Process													
Supplier			į										
Training													
Unapproved		<u> 1., </u>					<u> </u>				<u></u>		
							AUL	T CATE	GORY				
Landir	ng Gear				_	General		1		F	1 .		
	Bending			<u>_</u>	Bend		\perp	Grain			Ovalized	-	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	→	/Route	<u></u>	Hardwa			Over/Under		Temperature/Cure
]	Cracks			<u> </u>	Brok	en/Damaged	<u></u>	1	ion Incomplete		Part Incorre)	Weld
	Crushed/	'Crimped			Burrs		<u>_</u>	ł	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Conta	mination		Mainte	enance	<u></u>	Part Moved		
Ĺ	Heat Trea	at			⊣ !	tersink		Mislabe			Positioned V		
	Inspectio	n Strip in	Tube		-	oo Short		Misread	d		Power Loss/	'Surge	Other
	Ripples in	n Bend			_ Dril(Holes		Offset					
	Torque V	Vaves in I	Extrusio	n 📘	Draw	ving		Out of	Calibration				
	Turning S	Sequence	<u>!</u>		Finish	ı		Out of	Sequence				

Outside Dimensions

Date: ___

DQA:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print April-18-13 1:23:23 PM					·			. * *:	Р	age 7
Work Order ID: 100167		*10	0167*							
Parent Item: D3913-04	I		913-041*							
Parent Item Name: Long	Basket Base Assemby. 350	• 7.	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				art Date: 4/ tart Qty: 1.		Required Date: 5/02/13 Required Qty: 1.00	
AN3-10A	Purchased	No		150	Each	166.0000	6	6		
AN3-10A							**		BU 13-5-7	•
			Location	Lo	oc Oty	Loc Code				
			GA 122800		37 37	· · ·				
			ST351		41					
			124221		3					
			124858 ST512		38 88				•	
	/		122800		88			6		
AN960JD8 NA	AS1149DN832 Purchased	No		150	Each	0.0000	2	2.	•	!
AN960.ID8	*		123348.				**	2	BR 12-5-7.	:
D2931	Manufactured	No		150	Each	2,216.000	2	2		
D2931							**	-	161 13-5.7	·•
			Location	<u>Lo</u>	c Oty	Loc Code	;		÷	
		(GA 46064		218 218		-		* *	ŧ
		5	ST021		1998			_<		
D4001.5			86435		1998					
D4021-5	Manufactured	No		150	Each	20.0000	2	2	1.1 19 - 7	
D4021-5 Blanking Plate							**		Bl 13-5-7	
			Location STORA	<u>Lo</u>	c Oty	Loc Code				
			ST084 85065		20 2		-			
			89059		8					
			97893 🗸		10			<u> </u>		

NCR: Y	es / No				W	ORK ORDER NON-0	CON	FORN	MANCE / UP	DATE	QA Closed:	Date	·
Mark Orda				······································		DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Order						Rework Scrap	7		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality
Part N						Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite	1	re/Packaging Supplier	Other
Root				Descri	ption	of work order update	In	itial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or No	n-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
quip/Tooling						[[
Operator													
Material [
Setup							;						
Other													
Process											ļ		
Supplier													
Training []]										
Jnapproved							<u> </u>				<u> </u>		
						F	AULT	CATE	GORY				
Landin	g Gear				_	General				_	٦	Γ-	¬ .
	Bending				Ben	d	-	Grain		-	Ovalized	-	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOV	//Route		Hardwa	re		Over/Under	⊢	Temperature/Cure
	Cracks				Brok	en/Damaged		nspecti	on Incomplete		Part Incorre	<u> </u>	Weld
	Crushed/	Crimped		L_	Burr	\$ 		nstruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Cont	amination		Mainte	enance		Part Moved		
	Heat Trea	at			Cou	ntersink		Mislabe	led		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut 1	roo Short		Misread	d .		Power Loss/	'Surge	Other
	Ripples in	Bend			Drill	Holes_		Offset					
	Torque W	Vaves in E	Extrusion	1 [Drav	wing		Out of (Calibration				
	Turning S	equence	!		Finis	þ		Out of 9	Sequence				
ſ	Wave/Tw	ist in Tul	be		Folio	b ·	_[_](Outside	Dimensions				

DQA:

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April-18-13 1:23:23 PM

Work Order ID: 100167

Parent Item:

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

MS20600-AD4W3

Purchased

No

100167 *D3913-041*

Start Date: 4/18/13

Start Qty: 1.00

Required Date: 5/02/13 Required Qty: 1.00

1,319.000 **

MS20600-AD4W3 Cherry Rivets

Location	<u>Lo</u>	c Qty	Loc Code		
ST311		1186 , ,	,		
122151		4			
122452		4			
123525		294			
124231		884			2
WA003		133			
107939		133			
	150	Each	4,739.000	6	6

Each

MS21042L3

MS21042L3

Purchased

No

**

BL 13-5-7.

Location	Loc Oty	Loc Code
FP001	3	
122141	3	
GA	110	
122452	110	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	4354	

974

3380

150

April-18-13 1:23:23 PM

123900

124291

													,	
NCR: Ye	es / No				w	DRK ORDER NON-C	COI	NFORM	MANCE / UP	PDATE	DQA:		,	
					T						QA Closed:	Date:	The second secon	
Work Order:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part No					Rework Scrap Use-as-is Work Order Update		Machining Small Factorial Small Factorial Finishi		Crosstube Small Fab Finishing Composite	Prod. Eng. Coor Rec/Store/Packaging Supplie		Engineering Quality Other		
			,									· · · · · · · · · · · · · · · · · · ·		
Root Cause	Date	Step	Qty			of work order update n-conformance	1	nitial iief Eng	1	ction cription	Sign & Date	Verification	QC Inspector	
oc/Data quip/Tooling Operator Material Setup Other Process Gupplier Fraining Unapproved														
							AUL	T CATE	GORY					
Landin	Centre Not Concentric to O/S Cracks Brown Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube BON BON Cross Brown Cons			Brok Burrs Cont Cour	I/Route en/Damaged amination ntersink oo Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread		/Unclear	Over/Under tolerance Temper Part Incorrect Weld		Wrong Stock Pulled		
	Ripples in			_	- 1	Holes	-	Offset	C 111					
-	Torque V			` <u> </u>	Drav	_	\vdash	4	Calibration			· · · · · · · · · · · · · · · · · · ·		
-	Turning Sequence Finish Wave/Twist in Tube Folio					Out of Sequence Outside Dimensions								

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April-18-13 1:23:23 PM

Work Order ID: 100167 ·

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assemby. 350

100167
D3913-041

Start Date: 4/18/13

**

Start Qty: 1.00

Required Date: 5/02/13

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

8,690.000

12

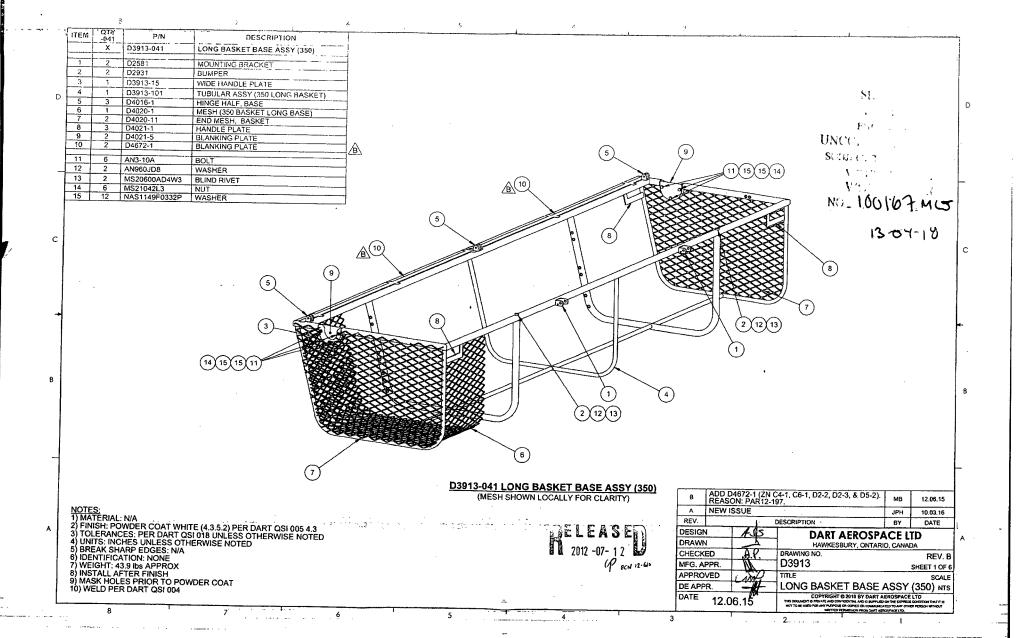
BU 13.5-7.

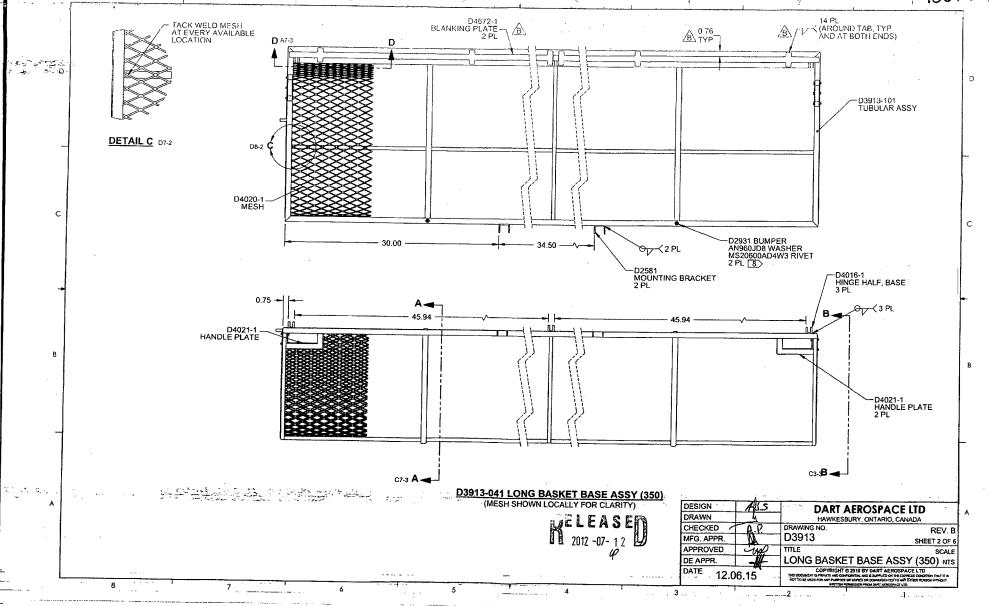
NAS1149F0332P

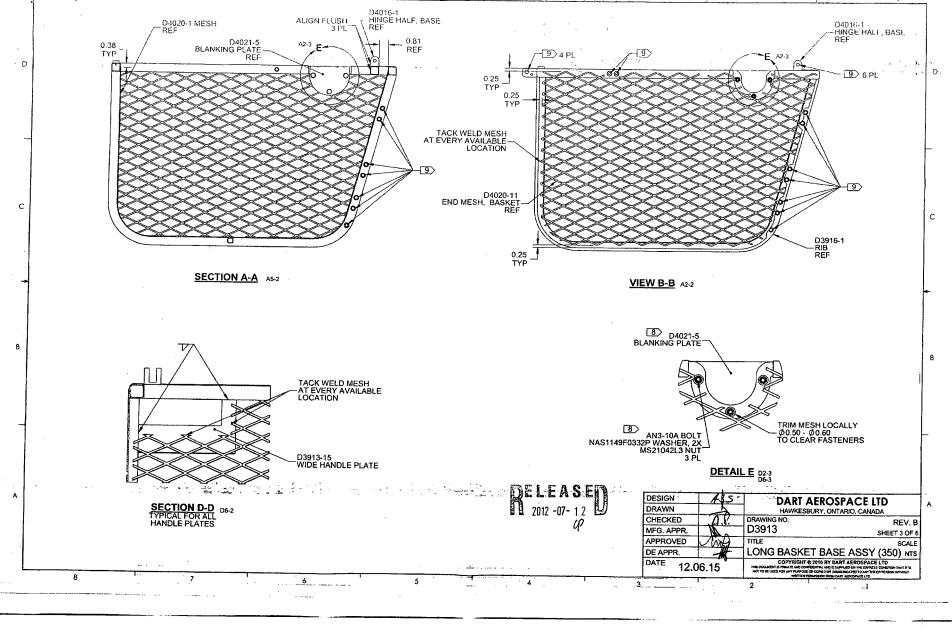
Location	!	Loc Qty	Loc Code	
GA		182		
	122063	182		
ST294		158		
	122063 ,	158		
ST295		3		
	123352	3		
st510		8347		
	123900	8347		_12

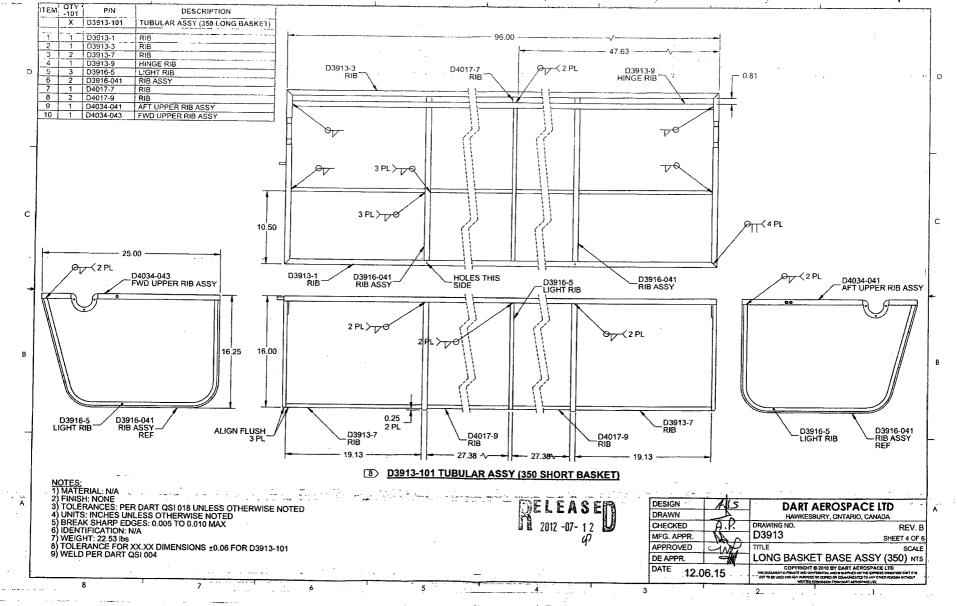
NCR: Ye	es / No				W	ORK ORDER NON-C	CON	NFORM	//ANCE / UP	DATE	DQA: QA Closed:		
•						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Order: Part No. NCR No.						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstub Machining Small Fa Thermoforming Finishin Large Fab Composit			Prod. Eng. Coor. Quality ing Rec/Store/Packaging Other		
Root				Descri	ption	of work order update	1	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Nor	n-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
quip/Tooling Operator Material etup Other Process supplier Training Unapproved													
							AUL	T CATE	GORY				
Landing	Bending Centre Not Concentric to O/S			вом	General Bend BOM/Route Broken/Damaged			re on Incomplete		Ovalized Pressure/Forced Over/Under tolerance Temperature/C Part Incorrect Weld			
-	Crushed/Crimped.			Burrs	_		Inspection Incomplete Instructions Incomplete/Unclear Maintenance		/Unclear			Wrong Stock Pulled	
	Heat Treat Inspection Strip in Tube			Cut	ntersink oo Short		Mislabe Misread			Positioned Power Loss,		Other	
-	Ripples in Bend Drill Holes				-	Offset	alibration						
-	Torque Waves in Extrusion Drawing Turning Sequence Finish Wave/Twist in Tube Folio					Out of Calibration Out of Sequence Outside Dimensions							

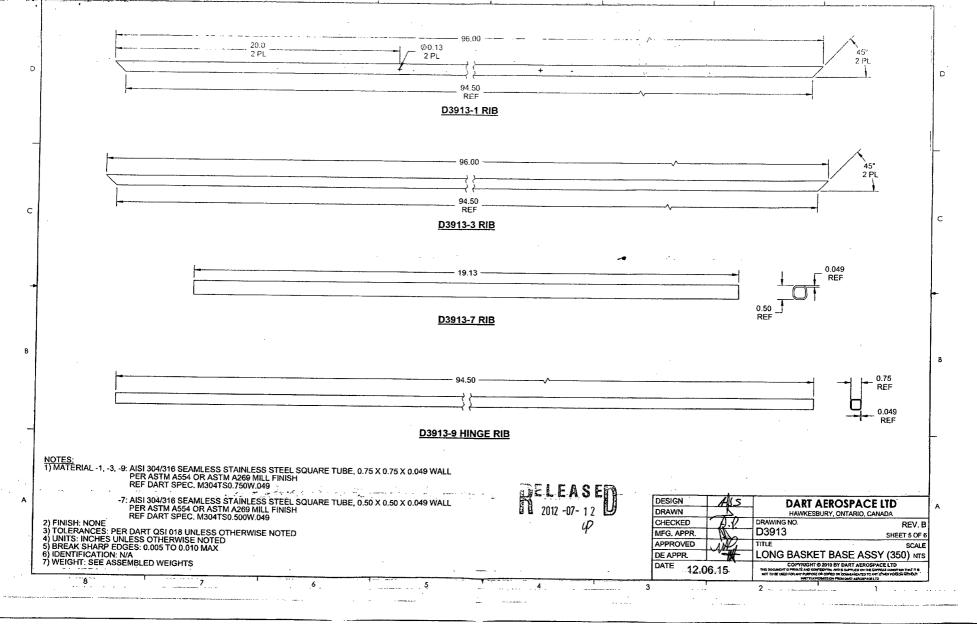
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

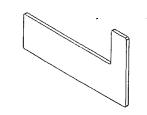


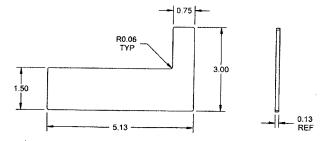










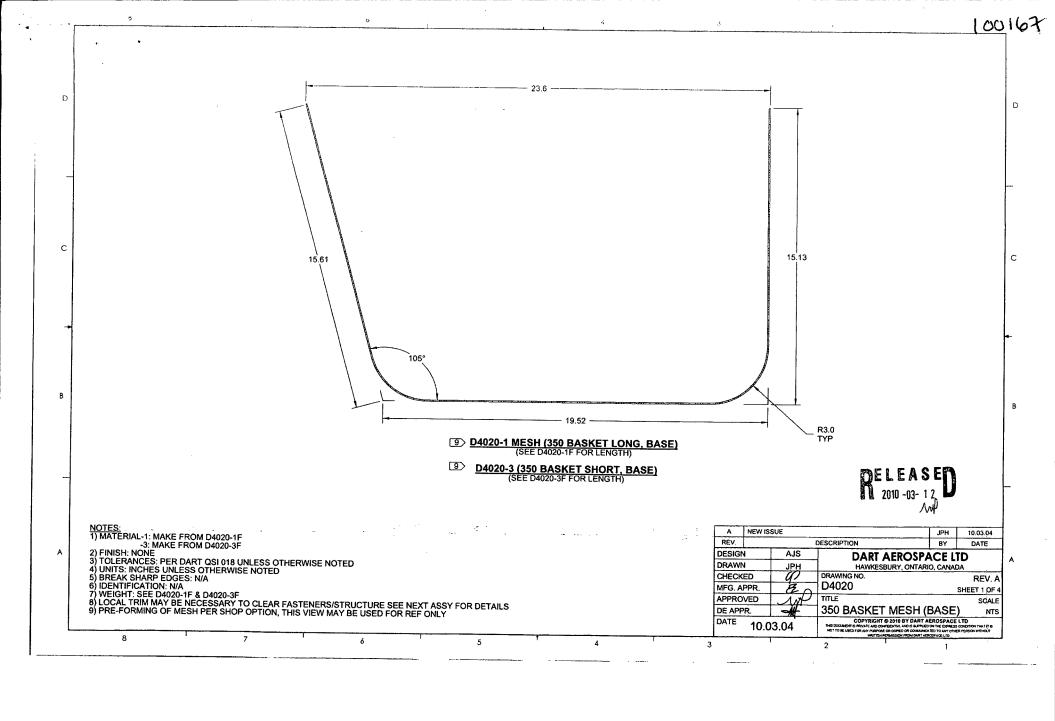


D3913-15 WIDE HANDLE PLATE

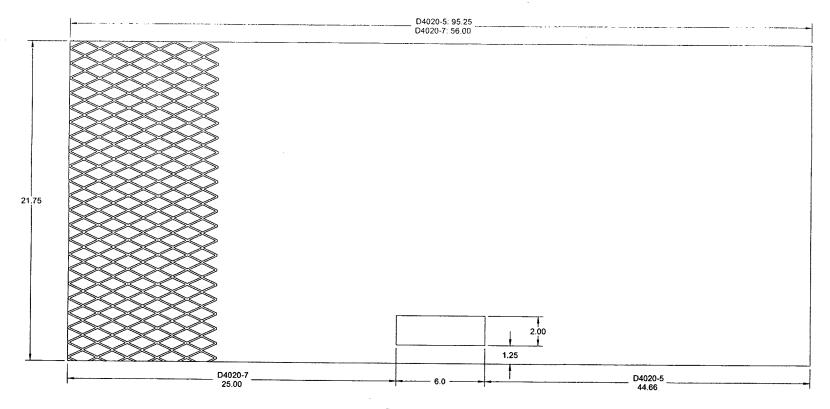
NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

1 2012 -07- 12 ã

1	1.	•	4
DESIGN	1.5	DART AEROSPA	ACEUD
DRAWN	5	HAWKESBURY, ONTAR	1
CHECKED	A.V.	DRAWING NO.	REV. B
MFG. APPR.	M	D3913	SHEET 6 OF 6
APPROVED	100	TITLE	SCALE
DE APPR.	4	LONG BASKET BASE	ASSY (350) NTS
DATE 12.0	06.15	COPYRIGHT © 2010 BY DART A THIS DOCUMENT IS PRIVATE AND CHEADITH, AND IS SUPPLES HOT TO BE USED FOR ANY PURPLES OF COPIED OF COMMANDO	ON THE EXPRESS CONSTRON THAT IT IS, ATED TO ANY OTHER PERSON WITHOUT



100167



D4020-5 MESH (350 BASKET LONG, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY)

D4020-7 MESH (350 BASKET SHORT, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY)

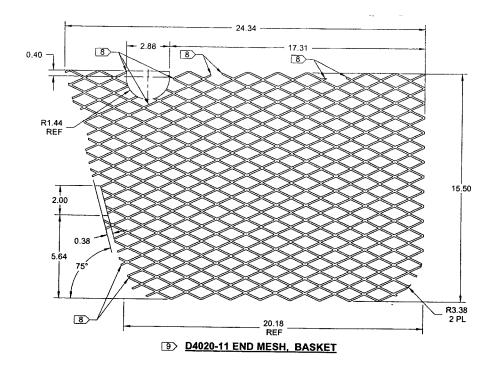
•	NOTES:	(9)
	1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F	
	REF DART SPEC. M304EX0.75-16F	
	2) FINISH: NONE	
	3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	
	4) UNITS: INCHES UNLESS OTHERWISE NOTED	
	5) BREAK SHARP EDGES: N/A	
	6) IDENTIFICATION: N/A	
	7) WEIGHT -5: 0.80 lbs APPROX	
	-7: 4.49 lbs APPROX	
	8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR	DETAILO
	9) TOLERANCE ON XX.XX DIMENSIONS + 0.06	DETAILS

DESIGN	AJS	■ DART AEROSPACE LTD	1
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	a	DRAWING NO.	REV. A
MFG. APPR.	星	D4020 SHE	ET 2 OF 4
APPROVED	JAP.	TITLE	SCALE
DE APPR.	-#	350 BASKET MESH (BASE)	NTS
DATE 10.0	3.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RUPPLED ON THE DEPORTS CONSTITUTION TO BE USED FOR ANY PURPOSE OR COPPED OR COMMUNICATED TO ANY DIMER PERSON WITTO PERSONANCE IN PROMINANT REPORANCE, IN PROPERTY REPORTS AND PROPERTY REPORANCE, INC.	

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NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 IbS

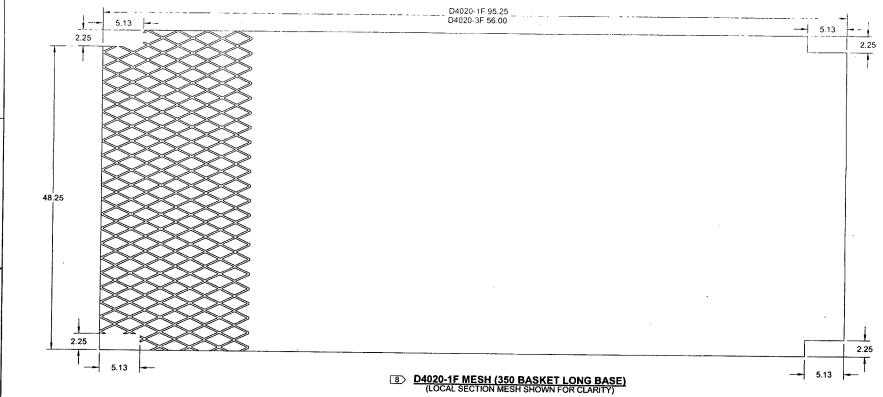
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7) WEIGHT. 1.210 MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS 9) TOLERANCE ON XX.XX DIMENSIONS $\pm\,0.06$.

DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN JPH DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 APPROVED 350 BASKET MESH (BASE) DE APPR. DATE 10.03.04 COPYRIGHT © 2010 BY DART AEROSPACE LTD

100167



(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A

5) BREAK SHARF EDGES, IVIA
6) IDENTIFICATION: N/A
7) WEIGHT-1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN	AJS	DART AEROSPACE LTD				
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA				
CHECKED	9	DRAWING NO. REV. A				
MFG. APPR.	En	D4020 SHEET 4 OF 4				
APPROVED	/W	TITLE SCALE				
DE APPR.	-#-	350 BASKET MESH (BASE) NTS				
DATE 10.0	3.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COOLINET IS PREVATE AND CONFEDERAL AND OS IMPRESO ON THE EXPRESS CONCINON THAT IT IS NOT TO DECLURED FOR NATH PROPERS OF COMPANIENTED TO ANY OTHER PRISON WITHOUT				